



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-041
Job Sheet 185829

008377



Part No: D4634-041

Job Qty: 1 pcs

Part Name: Fwd, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV G SHEETS 1,2 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Small Fab - 1	1 pcs	12/7/18		0.00	1.00	Small Fab - 1			58 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
120	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10			DAS 40 9-89
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
130	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B			DAS 69 9-89
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			
							Packaging 3 - 5 - B4B			

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	DAS 21	APR 15 2019
				QC 21 - SA - 70	9-55	

Part Op 110 - Small Fab (Small Fab)
 Descriptions: 120 - QC5 (QC5- Inspect part completeness to step on W/O)
 130 - Packaging3 (Identify as per dwg & Stock Location: _____)
 140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	1 Ea (1 ea)	110-Small Fab - 1	5007846
50-009-2	Grommet	1 Ea (1 ea)	110-Small Fab - 1	50057977
D4634-141	Fwd, Center Ceiling Replacement Panel Assembly	1 pcs (1 ea)	110-Small Fab - 1	5161458
D4646-1	Plenum Cap Assembly	2 pcs (2 ea)	110-Small Fab - 1	5138377
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	110-Small Fab - 1	5153960
D4728-047	Advisory Light, Fwd	1 pcs (1 ea)	110-Small Fab - 1	5048891
D4728-051	Cabin Lights #1	1 pcs (1 ea)	110-Small Fab - 1	5018473
D4743-1	Speaker Grill	2 pcs (2 ea)	110-Small Fab - 1	5008278
MS21044-N08	Nut	8 Ea (8 ea)	110-Small Fab - 1	500079447
MS24693-BB50	Screw	8 Ea (8 ea)	110-Small Fab - 1	500079447
NAS1149DN832J	Washer	8 Ea (8 ea)	110-Small Fab - 1	5131200
PLT1.5M-M	Tie Wrap	7 Ea (7 ea)	110-Small Fab - 1	5131200
				5153918

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2351-20-27-C3C	1	26	0
	50-009-2	1	149	0
	D4634-141	1	0	0
	D4646-1	2	32	0
	D4652-5	2	2	0
	D4728-047	1	6	0
	D4728-051	1	4	0
	D4743-1	2	23	0
	MS21044-N08	8	191	0
	MS24693-BB50	8	48	0
	NAS1149DN832J	8	1,277	0
	PLT1.5M-M	7	2,032	0
Part Specifications				
Specifications could not be found.				

Plex 1/24/19 8:58 AM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-041
Job Sheet 185829



Part No: D4634-041

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV G SHEETS 1,2 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs	12/7/18	12/7/18	0.00	1.00	Small Fab		
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	1 Ea (1 ea)	90-Start up Operation	
50-009-2	Grommet	1 Ea (1 ea)	90-Start up Operation	
D4634-141	Fwd, Center Ceiling Replacement Panel Assembly	1 Ea (1 ea)	90-Start up Operation	
D4646-1	Plenum Cap Assembly	2 Ea (2 ea)	90-Start up Operation	
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	90-Start up Operation	
D4728-047	Advisory Light, Fwd	1 Ea (1 ea)	90-Start up Operation	
D4728-051	Cabin Lights #1	1 Ea (1 ea)	90-Start up Operation	
D4743-1	Speaker Grill	2 Ea (2 ea)	90-Start up Operation	
MS21044-N08	Nut	8 Ea (8 ea)	90-Start up Operation	
MS24693-BB50	Screw	8 Ea (8 ea)	90-Start up Operation	
NAS1149DN832J	Washer	8 Ea (8 ea)	90-Start up Operation	
PLT1.5M-M	Tie Wrap	7 Ea (7 ea)	90-Start up Operation	

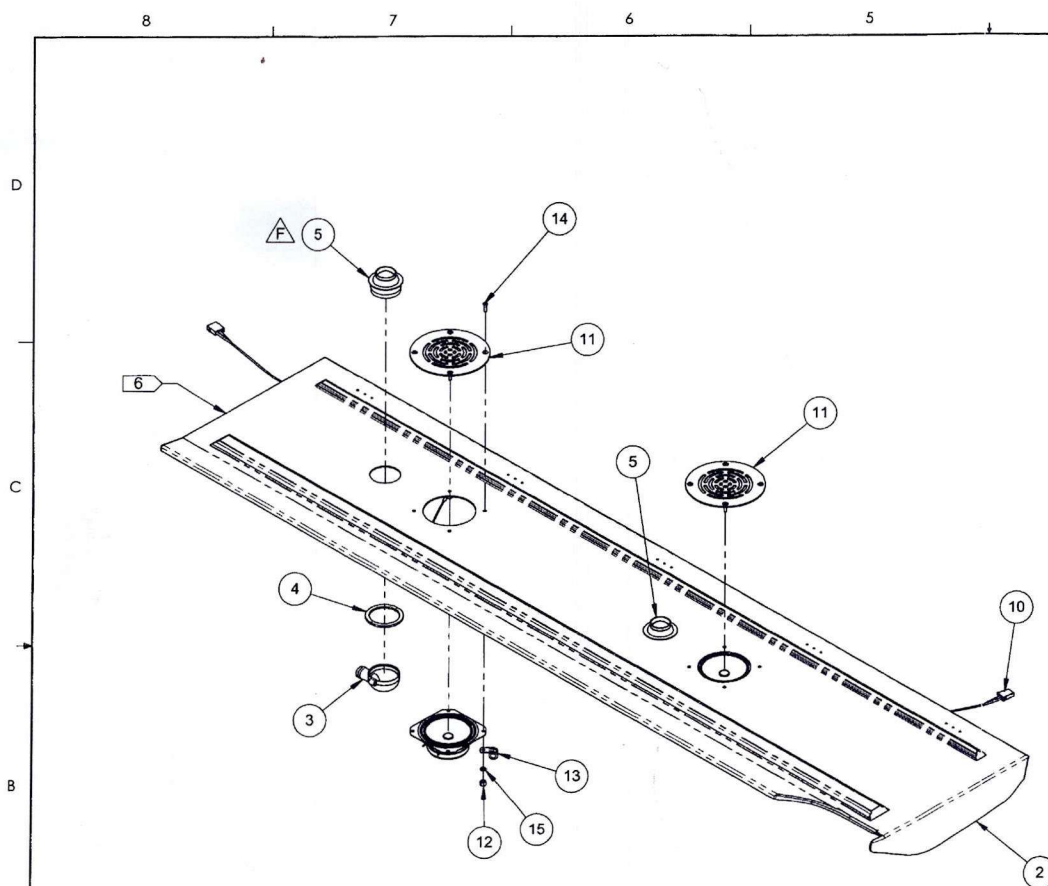
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-27-C3C	1	37	0
	50-009-2	1	185	0
	D4634-141	1	0	0
	D4646-1	2	1	0
	D4652-5	2	11	0
	D4728-047	1	9	0
	D4728-051	1	4	0
	D4743-1	2	23	0
	MS21044-N08	8	228	0
	MS24693-BB50	8	57	0
	NAS1149DN832J	8	942	0
	PLT1.5M-M	7	2,169	0

Part Specifications

Specifications could not be found.

Plex 11/2/18 3:45 PM dart.white.jesse



D4635-041 LH, FWD CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 8.0 lbs
- 8) INSTALL D4728-041/-043/-059 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -041	P/N	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
5	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-041	LH SPEAKER #1 HARNESS ASSY
9	1	D4728-043	LH SPEAKER #2 HARNESS ASSY
10	1	D4728-059	CABIN LIGHT HARNESS
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT, SELF-LOCKING
13	6	MS21919WDG8	CLAMP
14	8	MS24693-BB51	SCREW, CSK 100°
15	8	NAS1149DN832J	WASHER
16	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

RELEASED

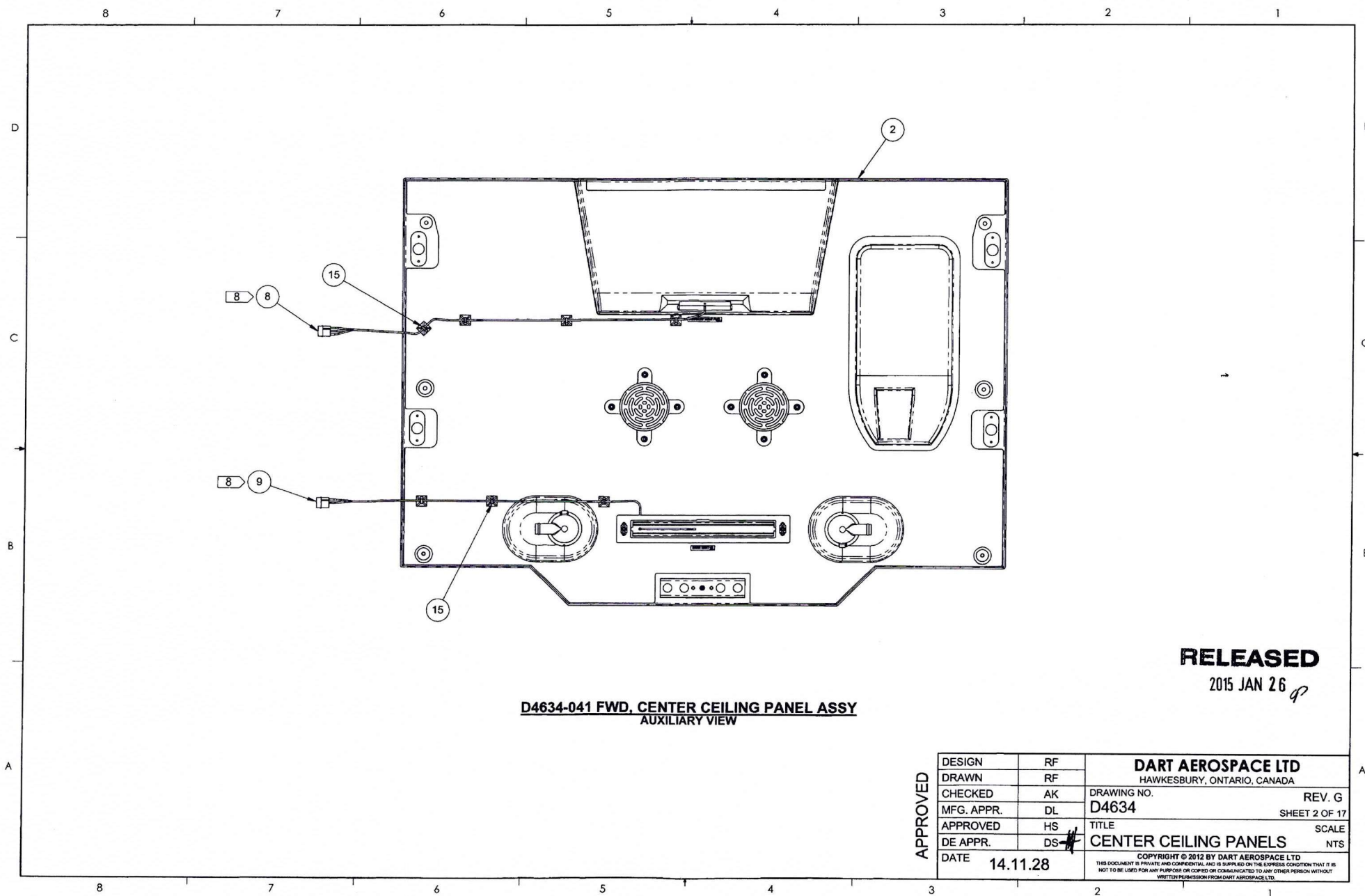
2015 JAN 26

ECN 14-634 4P

F	D4652-5 WAS D4652-1 (ZN D4-1, D4-3, D4-5, D4-7)	RF	14.11.28
E	REVISE BOM (ZN D4-1, D4-3, D4-5, D4-7); ADDED NOTE 11) (ZN A8-9, A8-10, A8-11 & A8-12); REVERSE VIEW -142/-144 (ZN B6-10, B6-12); RANGE 1.5-1.8 WAS 1.8 (ZN A7-17); DIMENSION HAS SHIFTED DUE MATERIAL THICKNESS	RF	14.01.09
D	CORRECTING VIEW FOR ITEM 8 (ZN B2-2); ADDED D5022-1 (ZN D4-9, C3-9, D4-10, C2-10), D5022-3 (ZN D4-11, C6-11), D5022-5 (ZN D4-12, B6-12); DIMENSION SHIFTED DUE ADDING D5022-1/-3/-5; REVISE NOTE 10) (ZN A8-9, A8-10, A8-11, A8-12); NOTE 1) (ZN A8-13, A8-14, A8-15, A8-16)	RF	13.12.09
C	REVISE NOTE 8) (ZN A8-9, A8-10, A8-11 & A8-12); 32 WAS 34 (ZN C5-15, B5-16); CORRECT TYPO #1 WAS #3 (ZN D4-3); CHANGE TOLERANCE (ZN C3-13, B2-14, B5-17, B7-17, D2-17, D4-17, A3-18)	RF	13.06.18
B	ADDED D4635-141/-142/-143/-144 (ZN B4-9, B4-10, B4-11, B4-12); REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADDED D4732-41 (ZN B5-8); CHANGE TO D4743-1 SPEAKER GRILL AND MS24693-BB51 SCREWS (SHT 1, 3, 5, 7); ADD VIEWS R-R (ZN A7-17) AND S-S (ZN A5-17); UPDATE DETAIL 'D' (ZN C7-18)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 1 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR CONSEQUENCES TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4634-041 FWD, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED

2015 JAN 26 *q*

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DL	D4634	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	
DATE	14.11.28	NTS	
COPYRIGHT © 2012 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART
AEROSPACE

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dart-aero.com
www.dartaerospace.com

Container No: S162324

Part: D4634-041

Job No: 185829

Serial No/Batch: S162324

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/13/19